

Date: Friday, 11/01/2008 10:59:54 AM
User: Linda Lacelle

Dart Aerospace Ltd.

Process Sheet

Split 08-01-15

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 36710A - 1
Estimate Number : 10353
P.O. Number : N/A
This Issue : 11/01/2008 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 33253B
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 05-11-07 JLM
Est Rev:B Now 6061-T6 06-06-23 JLM
Est Rev:C New flat pattern 08.01.11 EC

Drawing Name : STEP LEG
Part Number : D2278
Drawing Number : D2278 REV F
Project Number : N/A
Drawing Revision : F
Material : N/A
Due Date : 15/01/2008 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s)

Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick m 5052H 32S080

(M6061T62S.080)

Identify as D2278

Batch: 100947 x28 IB 8-1-14

100742 x 10 = 10.306

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2278

Dwg Rev: F

Prog Rev: F

2-Deburr if necessary

IB 8-1-14

IB 8-1-14

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE


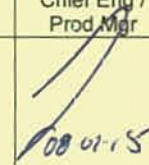
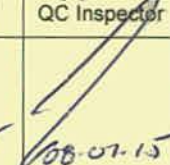
4.0 QC8 SECOND CHECK




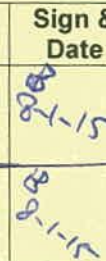

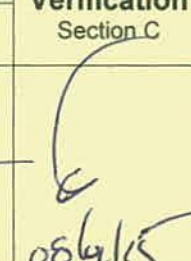
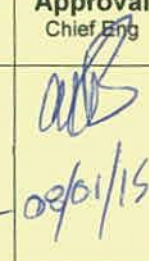
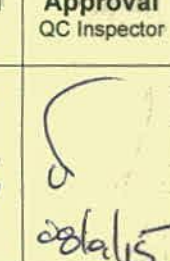
Comment: SECOND CHECK

08/01/15 (x30)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-01-15	3.0	split for a qty of 8 parts needed on 1 hr - 2 split Qty 36 remain of this order.		08-01-15	8	 08-01-15	 08-01-15

Part No: D2278 PAR #: N/A Fault Category: Prod/FAB. ASS. ^{media Sample} NCR: Yes No DQA: 10 Date: 08/01/17
QA: N/C Closed: _____ Date: _____

NCR: <u>36710A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/15	12	44 parts SCRAP. Parts 0.100" too short in width. 8.46 → 8.36" Rt. wrong program on memory stick. Human error	 08/01/15	Clean old memory stick. SCRAP and destroy all 44 parts. Replace B2 100917 / 100142	 8-1-15  8-1-15	 08/01/15	 08/01/15	 08/01/15

NOTE: Date & initial all entries

Date: Friday, 11/01/2008 10:59:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 36710A

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(30)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-01-16

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(30x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/16

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: mf

08-01-16 (30)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

08/01/17

Job Completion



08.01.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36710A
Description: STEP LEG		Part Number:	D2278
Inspection Dwg: D2278 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ .128	+ .005 - .001	.131	✗			
.354	± .010	.354	✗			
2.604	± .010	2.604	✓			
4.854	± .010	4.854	✗			
7.104	± .010	7.104	✗			
9.354	± .010	9.354	✗			
11.604	± .010	11.604	✗			
13.854	± .010	13.854	✗			
16.104	± .010	16.104	✗			
16.46	± .030	16.46	✗			
.354	± .010	.354	✗			
2.00	± .030	2.008	✗			
4.74	± .030	4.748	✗			
.750	± .010	.754	✗			
.213	± .010	.217	✗			
1.994	± .010	1.995	✗			
2.701	± .010	2.701	✗			
3.409	± .010	3.409	✗			
4.116	± .010	4.116	✗			
4.824	± .010	4.826	✗			
5.304	± .010	5.304	✗			
8.46	± 0.030	8.45	✗			

Measured by:	B
Date:	8-1-15

Audited by:	J
Date:	08/01/15

Prototype Approval:	✓
Date:	8/1/15

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

